

Date: Tuesday, 11/14/2006 10:13:39 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER		
Job Number	: 29453		Part Number	: D2884		
Estimate Number	: 11055		Drawing Number	: D2884 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/14/2006 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 11/30/2006 Qty: 40 Um: Each		
Previous Run	: 28259					
Written By	: <u>ml 06 11 14</u>					
Checked & Approved By	: <u>ml 06 11 14</u>					
Comment	: Est A 99.10.12 New Issue EC Est Rev:B Now 6061-T6 06-06-23 JLM Est Rev:C Now on Waterjet 06-08-23 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
		 Comment: Qty.: 0.0663 sf(s)/Unit Total : 2.6502 sf(s) Material: 6061-T6 0.080" Thick Batch <u>M102448</u> <u>ml 06 11 30</u>
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D2884 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> <u>ml 06 11 30</u>
		 Comment: 2-Tumble ,Deburr if necessary <u>SAW 06:12:03</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <u>ml 06 11 30</u>
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 <u>ml 06 11 30</u>
		 Comment: SECOND CHECK
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <u>SAW 06:12:03</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/12/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:13:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 29453

Part Number: D2884

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>2012-04 40</i>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
7.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>2012-05 40</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>st 393</i>		
8.0	QC21	FINAL INSPECTION/W/O RELEASE <i>2012-05 40</i>
Comment: FINAL INSPECTION/W/O RELEASE <i>2012-05</i>		

Job Completion



2012-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

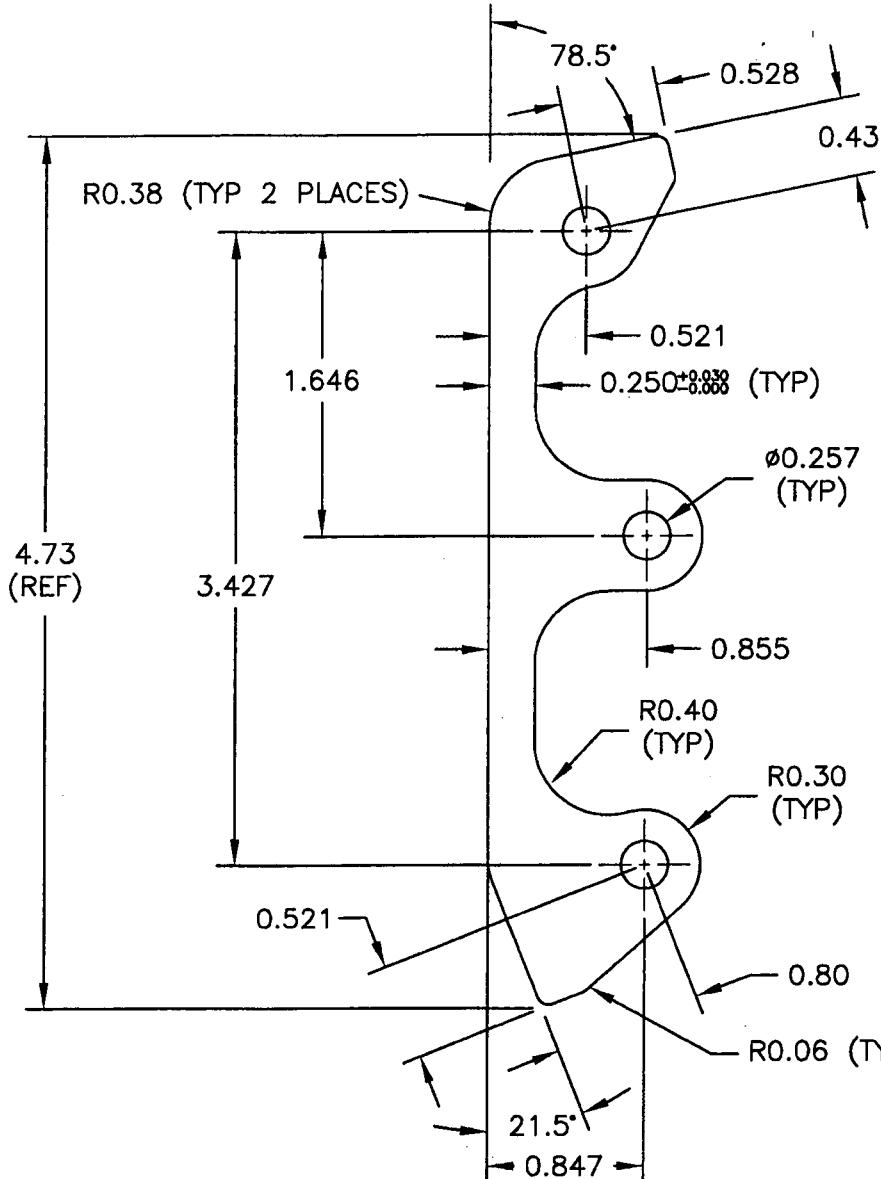
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CB	DART AEROSPACE LTD
CHECKED	PH	APPROVED	SH	HAWKESBURY, ONTARIO, CANADA
				DRAWING NO. D2884
DATE	06.05.29			REV. B
				SHEET 1 OF 1
A	99.04.01			SCALE 1:1
B	06.05.29			ADD 6061-T6 MATERIAL



RELEASED

06.06.20 SH

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080) OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29453

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DART AEROSPACE LTD

Work Order: 29453

Description: Saddle Space

Part Number: D2884

Inspection Dwg: D2884 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article

x Prototype

Measured by:

07/07/01

Audited by:

200

Prototype Approval:

Date:

8

1000

100

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REV.

Date: 8/13/20

Date: 10/11/32

REVIEWS